

Work Order ID 58259

Monday, May 03, 2010 9:00:36 AM



Page 1

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Item Name: Long Basket Lid Assembly (350)

Stop



Start Date: 5/3/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 5/7/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: mt Date: 10-5-3

Tooling:

Date:

Run Start



QC: Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

A

100

Weld per dwg A/R S.S. rod Batch: 111679 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914

10-05-13

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

10-05-14

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Run Start

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Date:

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Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Scolos 119

①

130

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00



Powdercoat

M112588

Memo

0.00

Powder Coating

start time 12:00pm = 10/05/19 x1
Fin time 1:30pm
Temp 320°C

140

Wing Walk as per dwg QSI005 4.4 Batch 114432

0.00



HandFinish

Memo

0.00

Hand Finishing

- 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
- 2- Install placard and label as per dwg

① 10-5-19

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 5/05/19 @

160

Identify as per dwg & Stock Location: GA

0.00



Packaging

41058314
Memo

0.00

Packaging

EP 5/05/19 @

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/2019

-MF

10-5-19

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Picklist Print

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Page 1

Work Order ID: 58259

Parent Item: D3914-041.

Parent Item Name: Long Basket Lid Assembly (350)

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Date: 5/3/2010

Required Date: 5/7/2010

Start Qty: 1.00


Required Qty: 1.00


Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------


D2581  Mounting Bracket		Manufactured	No			100	Each	27.0000	2			
--	--	--------------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

WA 27
46086 2
51745 2
57185 23


D2728-3  Dart Logo label		Manufactured	No			140	Each	0.0000	1			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

D3914-1  Rib		Manufactured	No			100	Each	0.0000	2			
---	--	--------------	----	--	--	-----	------	--------	---	--	--	--

D3914-7  Rib		Manufactured	No			100	Each	2.0000	2			
--	--	--------------	----	--	--	-----	------	--------	---	--	--	--

Location Loc Qty Loc Code

WA 2
57573 2

D4016-3  Hinge Half, Lid		Manufactured	No			100	Each	13.0000	3			
---	--	--------------	----	--	--	-----	------	---------	---	--	--	--

Location Loc Qty Loc Code

ST109 12
57574 12
WA 1
56950 1

SAD 10-05-12

5/10/05/19

SAD 10-05-12

SAD 10-05-12

SAD 10-05-12

3

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Page 2

Work Order ID: 58259

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)















Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D4018-5  Rib		Manufactured	No			100	Each	0.0000	9			
						B58244					SAD	10-05-12
D4020-5  Mesh (350 Basket Long, Lid)		Manufactured	No			100	Each	1.0000	1			
											SAD	10-05-12
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
				WA	58041	100	Each	2.0000	1			
						58245					SAD	10-05-12
D4021-3  Data Plate		Manufactured	No			100	Each	2.0000	1			
											SAD	10-05-12
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
				WA	56050	1						
						57109					SAD	10-05-12
D4035-041  Lid Rib Assembly, Fwd (350 Basket)		Manufactured	No			100	Each	1.0000	1			
											SAD	10-05-12
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
				WA	57575	1						
						B58192					SAD	10-05-12
D4035-043  Lid Rib Assembly, Aft (350 Basket)		Manufactured	No			100	Each	1.0000	1			
											SAD	10-05-12
<div> <div>Location</div> <div>Loc Qty</div> <div>Loc Code</div> </div>												
				WA	56983	1						
						B58193					SAD	10-05-12

Monday, May 03, 2010 9:00:35 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 58259



Parent Item: D3914-041



Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 5/3/2010

Required Date: 5/7/2010

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	---------------	----------------	--------

D4086-210

Manufactured No

140

Each

8.0000

1



Placard, Max Load



Location

Loc Qty

Loc Code

ST112

8

56978

8

1

MF 10-5-19

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

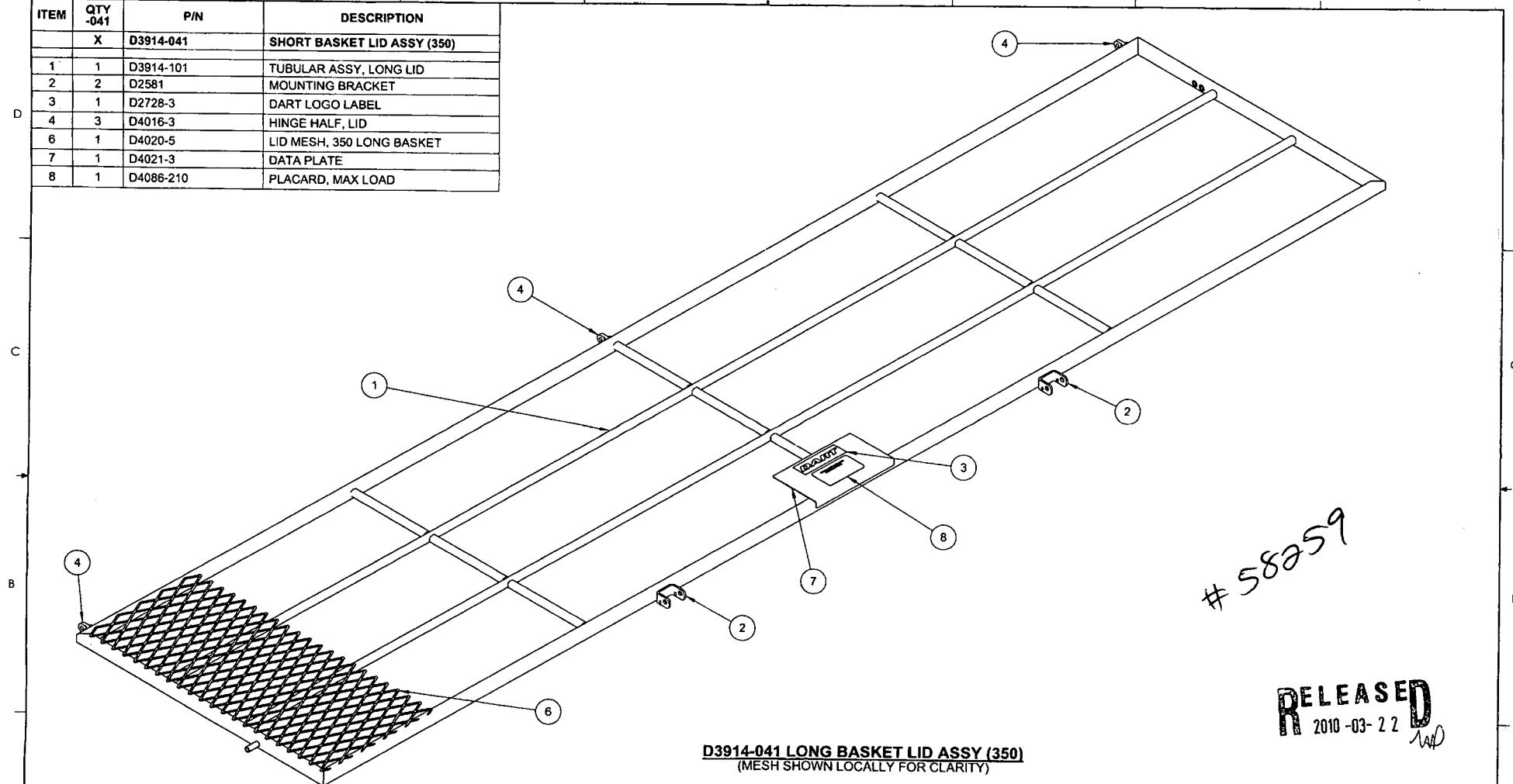
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	SHORT BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE
8	1	D4086-210	PLACARD, MAX LOAD



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

58059

RELEASED
2010-03-22

A NEW ISSUE		JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3914	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.03.16	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

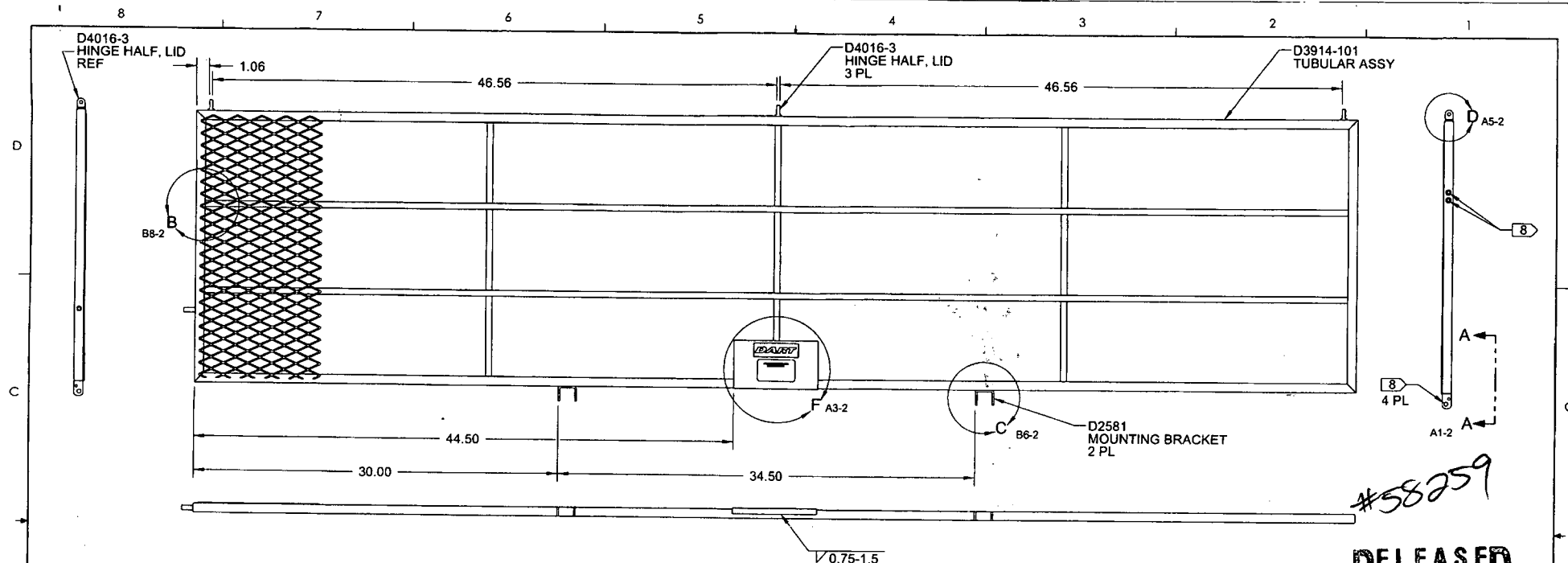
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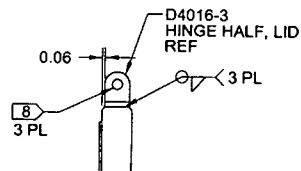
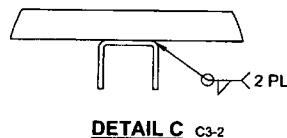
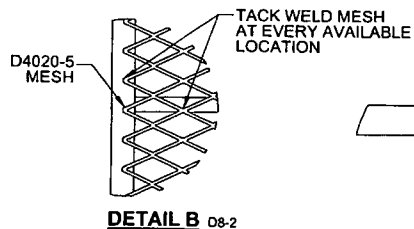
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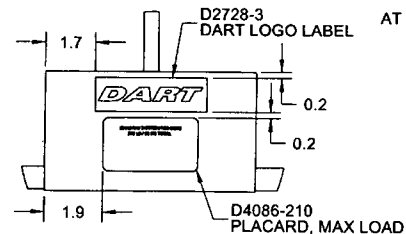
NOTE: Date & initial all entries



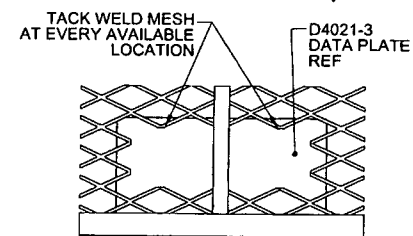
D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



DETAIL D D1-2



DETAIL F C4-2



VIEW A-A C1-2

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JS	DRAWING NO. D3914	REV. A
MFG. APPR.	JS	TITLE LONG BASKET LID ASSY (350)	SCALE NTS
APPROVED	JS	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DE APPR.	JS		
DATE	10.03.16		

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2010-03-22

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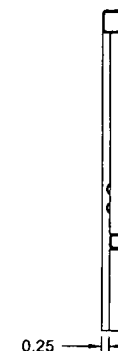
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, BASKET LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E CS-3

#56259

D4035-041
RIB ASSY, FWD

D4035-043
RIB ASSY, AFT

○ TYP

E C2-3

○ TYP

E

22.50

6.67
TYP

TYP ○

D3914-1
RIB
2 PL

D4018-5
RIB
9 PL

D3914-7
RIB
2 PL

23.25
TYP

8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
2010-03-22
AND

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

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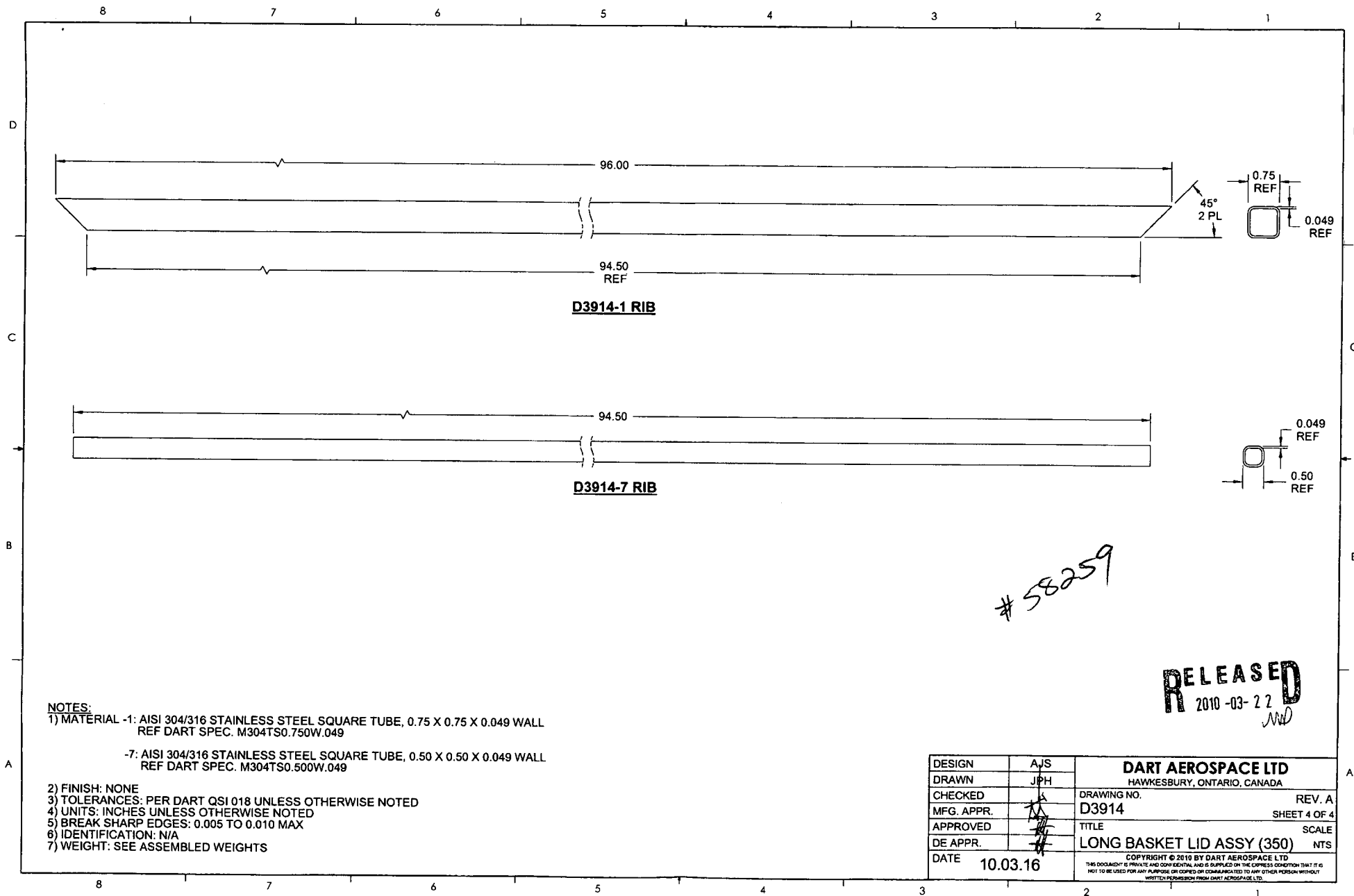
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